

Work Centers: Key Program Features

Work Center Maintenance CAP100

Significant Fields Affecting Costing

∇ Rates 1-4

- ◇ up to 4 labor rates or overhead rates can be referenced

∇ Cost load codes 1-4

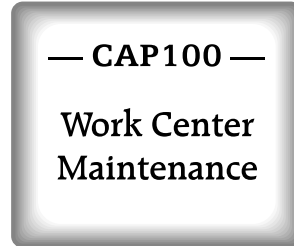
- ◇ indicates the hours used for calculating costs

Note: Don't confuse the cost load code with the capacity load code.

- 0 no hours
- 1 machine hours
- 2 setup hours
- 3 setup and machine hours
- 4 run hours
- 5 setup and run hours
- 6 run and machine hours
- 7 indirect hours
- 8 setup, run and machine hours
- 9 percentage of another rate

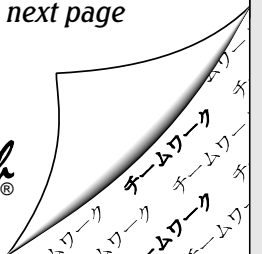
∇ % of rate 1-4

- ◇ indicates the specific overhead rate the system is to use to calculate a percent
- ◇ this field is used only if the cost load code is 9



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Work Center Loading Codes

Capacity Loading Codes

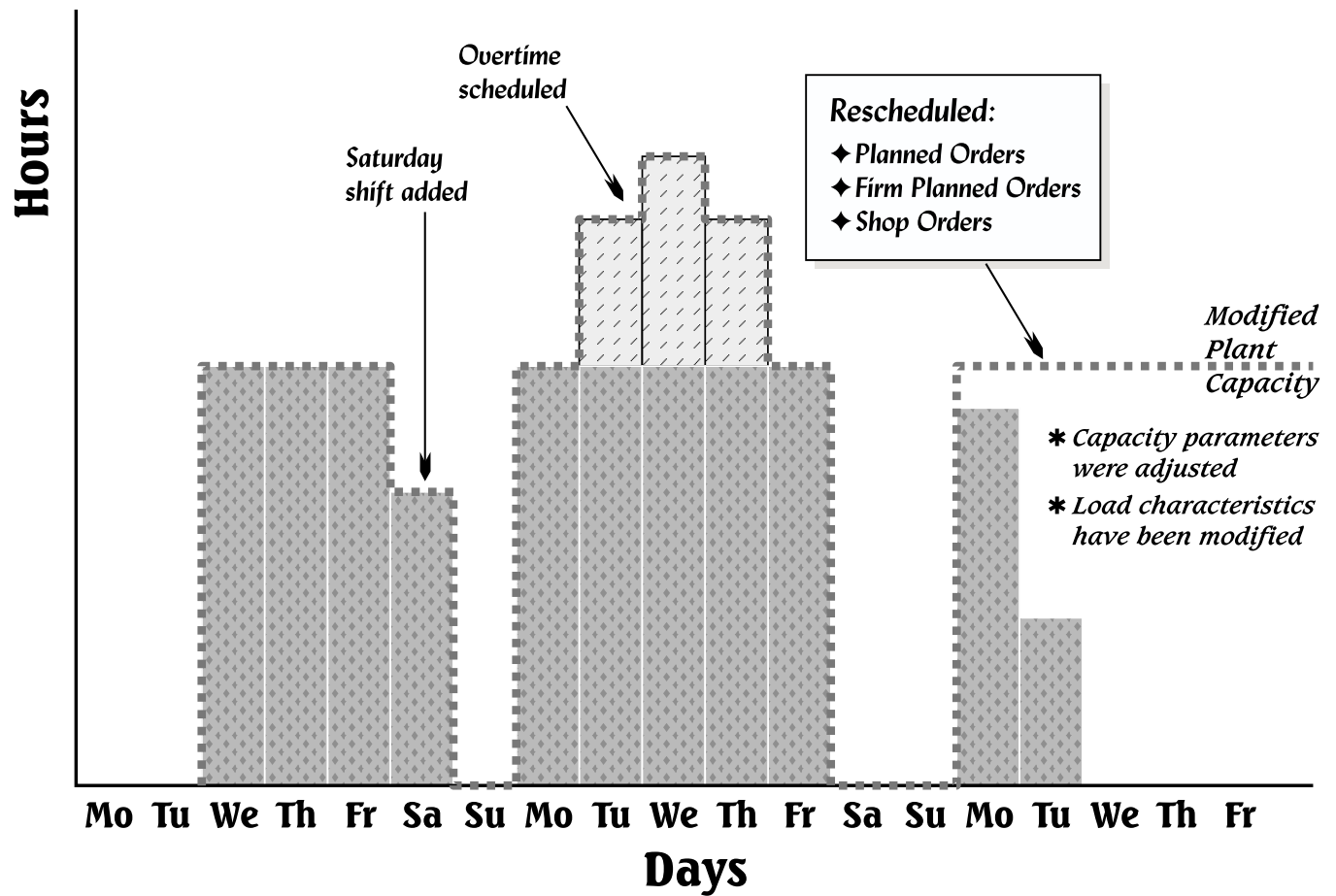
Capacity loading codes indicate type of operation or load hours from item routings and are identified for:

- ∇ Capacity planning (accumulating work center load)
- ∇ Scheduling of operations (consuming elapsed time) at a work center
- ∇ Each work center has only one capacity loading code

Code	Value	Capacity and Scheduling Usage
0	No Hours	<p>Will not accumulate any hours for capacity planning</p> <p>Routings with hours at this work center will NOT consume any time for scheduling the operation</p> <p>May be used for a work center representing a vendor for outside operation processing</p> <p>Could represent work centers with indirect labor operation for which you do NOT want capacity load reflected</p>
1	Machine Hours	Hours representing automatic loading with no operator intervention
2	Setup Hours	Hours representing fixed time for setting up or tearing down an operation
3	Setup and Machine Hours	A combination of 1 and 2
4	Run Hours	Hours representing direct labor/people operating a work center
5	Setup and Run Hours	A combination of 2 and 4

Finite Forward Scheduling

Finite Forward Scheduled Loading



- ∇ Corrective action taken to increase available capacity
- ∇ Minimizes order rescheduling
- ∇ Modified using Finite Forward Scheduling (MRP640)

— MRP640 —
Finite Forward Scheduling

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Inquiries: Key Program Features

Detail Capacity Inquiry CAP300

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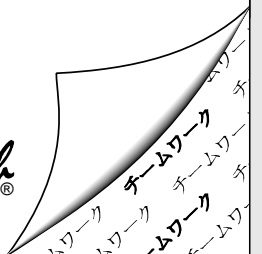
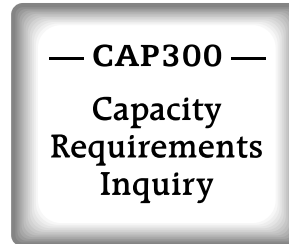
Pegged Requirements Screen

Header Information

- ∇ Work center number and description
- ∇ Desired load percentage
- ∇ Efficiency percent
- ∇ Department number
- ∇ Last capacity generation date
- ∇ Current load
- ∇ Total load
- ∇ Horizon date
- ∇ Period-to-date hours in and out
- ∇ Standard capacity
- ∇ Year-to-date hours
- ∇ Number of machines
- ∇ Number of shifts

Detail Information

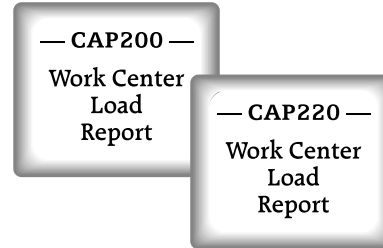
- ∇ Reference: (*Planned, Firm planned, Shop order number*)
- ∇ Date
- ∇ Hours
- ∇ Quantity
- ∇ Item number
- ∇ Item description



Reports and Listings: Key Program Features

Work Center Load ReportCAP200 / CAP220

Parameters continued from the previous page.



Parameters

∇ MRP time frame

- ◇ this field allows user selection of time periods to be used on the bottom line (the horizontal axis of the graph)

∇ Report option

- ◇ 1 Enter "1" to print the rough cut report
 - ◆ this option will create a report from the data generated in the rough cut capacity generation
 - ◆ this report analyzes master scheduled items with components processed through a critical work center
 - ◆ only planned and firm planned orders are printed
- ◇ 2 Enter "2" to print the detail report
 - ◆ this option will create a report from the data generated in the detail capacity generation
 - ◆ this report analyzes all items and all work centers
 - ◆ this report prints planned orders, firm planned orders and released shop orders

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